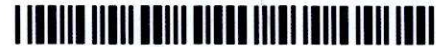




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D3043-041
Job Sheet 204389



Part No: D3043-041

Job Qty: 3 pcs

Part Name: Step Weldment LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/9/19

Job Tracking No:

Due Date: 10/9/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Lead Time	
100	Large Fab - Steps - 1	3 pcs	10/9/20		0.00	0.75	Large Fab - 1	<i>SL</i>
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
							Large Fab - 12	
110	QC 6 QC 5	3 pcs	10/9/20		0.00	0.00	QC 6 - 9	<i>D/</i> <i>4i</i> <i>DAS</i> <i>98</i> <i>82</i> <i>9-89</i> MAR 12 2020
							QC 6 - 68	
							QC 6 - 61	
							QC 6 - 40	
							QC 6 - 81	
120	Large Fab - Steps - 2 - B4B	3 pcs	10/9/20		0.00	2.00	Large Fab - 1 - B4B	<i>SL</i>
							Large Fab - 10 - B4B	
							Large Fab - 2 - B4B	
							Large Fab - 3 - B4B	
							Large Fab - 4 - B4B	
							Large Fab - 5 - B4B	
							Large Fab - 6 - B4B	
							Large Fab - 7 - B4B	
							Large Fab - 8 - B4B	
							Large Fab - 9 - B4B	
							Large Fab - 11 - B4B (Various)	
							Large Fab - 12 - B4B	
130	QC 9	3 pcs	10/9/20		0.00	0.00	QC 9 - 10	

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140 QC 5	3 pcs	10/9/20	0.00 0.00	QC 9 - 18	
				QC 9 - 24	DAS
				QC 9 - 43	24
				QC 9 - 50	9-89
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS
				QC 5 - 3	24
				QC 5 - 43	9-89
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
150 Handfinish - 1-1 Chemical-B4B	3 pcs	10/9/20	0.00 0.50	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SA MAR 20 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
160 Large Fab - Steps - 3 - B4B	3 pcs	10/9/20	0.00 1.50	Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	DAS
				Large Fab - 4 - B4B	24
				Large Fab - 5 - B4B	9-89
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	

170 QC 10	3 pcs	10/9/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS
				QC 10 - 50	43
				QC 10 - 58	3-88
				QC 10 - 9	
				QC 10 - 68	
180 QC 5	3 pcs	10/9/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	43
				QC 5 - 49	9-88
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
200 Handfinish - 6-1- Touch Up- B4B	3 pcs	10/9/20	0.00 0.50	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	★ MAR 23 2020
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
210 Powdercoat - 1 White Gl(A)- B4B	3 pcs	10/9/20	0.00 0.75	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	20-03-05
				Powdercoat - 4 - B4B	
220 Handfinish - 3-1- WingWalk- B4B	3 pcs	10/9/20	0.00 1.50	Handfinish - 3 - 1 - B4B	20-3-30
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
230 QC 3	3	10/9/20	0.00 0.00	QC 3 - 10	

pcs					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	DAS 82 9-89
					QC 3 - 19	
					QC 3 - 43	APR 03 2020
					QC 3 - 24	
					QC 3 - 61	QC 3 - 82
					QC 3 - 81	
240	Packaging 3-1 - Stock - B4B	3	10/9/20	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	DAS 72 9-89
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
250	QC 21 - SA	3	10/9/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89 APR 24 2020

pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Fabricate per Drwg)1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup
 Descriptions: DT8185-G 2-Debur and bevel ends for welding

110 - (QC6- All purchased or subcontracted products)

120 - (Fabricate per Drwg)1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802 AR AL ROD
 Batch: 139019 2-Grind Fwd End Cap weld flush

130 - QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (Fabricate per Drwg)1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: 4139019 2-
 Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - QC5- Inspect part completeness to step on W/O)

200 - (Touch up alodine)

210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

220 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

230 - (QC3- Inspect Part Finish)

240 - (Identify as per dwg & Stock Location: _____)

250 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	3 pcs (1 ea)	100-Large Fab - Steps - 1	<u>S243427</u> ✓
D2734	Step End Plate	6 pcs (2 ea)	100-Large Fab - Steps - 1	<u>S259067</u> ✓
D3040-1	Mounting Lug	6 pcs (2 ea)	100-Large Fab - Steps - 1	<u>S213057</u> ✓
D3040-3	Mounting Lug	6 pcs (2 ea)	100-Large Fab - Steps - 1	<u>S213129</u> ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	3	44	0
	D2734	6	23	0
	D3040-1	6	0	0
	D3040-3	6	0	0

Part Specifications

Specifications could not be found.

100-14982

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S263261



Part: D3043-041

Job No: 204389

Serial No/Batch: S263261

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/12/20